

Date: Tuesday, 5/23/2006 8:12:27 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L BASKET BASE
 Job Number : 27160A
 Estimate Number : 11273
 P.O. Number : N/A Part Number : D2252041
 This Issue : 5/23/2006 S.O. No. : N/A Drawing Number : D2252
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : E
 Previous Run : 26878A Material : N/A
 Due Date : 6/6/2006 Qty: 1 Um: Each
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *06-01-23 W*
 Comment : Est Rev: I Revised as per Rev E 05-12-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D31661 Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part# Description Batch
 5 D3166-1 Hoop *626717*

PD 06-05-29

2.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: *M100783*

PD 06-05-29

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 5 D2235-1 From D3166-1

2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

4-Deburr & Remove all Markings from Material

PD 06-05-29

4.0 D22531 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
 2 D2253 Gusset *B12413*

PD 06-06-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:12:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 27160A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing B25823

PD

06-06-08

6.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Chamel B26204

PD

06-06-08

7.0

D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug B23421

PD

06-06-08

8.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE B24527

PD

06-06-08

9.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description Batch

32 sf M304EX0.75-16F Expanded Metal H100981

PD

06-06-08

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig Debur as required

A/R SS ROD Batch: H100527

PD

06-06-08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
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| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/23

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:12:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 27160A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/06/08

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/06/20

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-06-22

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

B27160

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/23

Job Completion



06-06-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



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05.11.26

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| DESIGN KE | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D2252 | REV. E SHEET 1 OF 5 |
| DATE 05.11.10 | | TITLE BASKET ASSEMBLY (206L) | SCALE NTS |
| C | 95.12.11 | RE-DRAWN | |
| D | 99.09.14 | MODIFIED LATCH, D2581 WAS D2255-3 | |
| E | 05.11.10 | D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19 | |

E

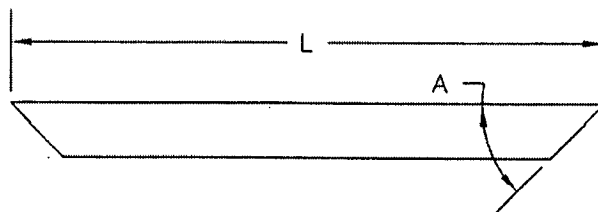
E

E

| Qty -041 | Qty -043 | Part Number | Description | L | A |
|-------------|-------------|-------------|------------------------|-------|----|
| X | | D2252-041 | BASKET ASSEMBLY | | |
| | X | D2252-043 | LID ASSEMBLY | | |
| | 2 | D2232-1 | HINGE | | |
| 2 | | D2232-3 | HINGE | | |
| 5 | | D2235-1 | RIB | | |
| 2 | 2 | D2252-1 | FRAME | 25.50 | 45 |
| 2 | | D2252-3 | FRAME | 96.00 | 45 |
| | 2 | D2252-7 | FRAME | 24.00 | 90 |
| 1 | | D2252-9 | FRAME | 10.25 | 90 |
| 1 | | D2252-11 | FRAME | 25.00 | 90 |
| 1 | | D2252-13 | FRAME | 42.00 | 90 |
| 1 | | D2252-15 | FRAME | 15.00 | 90 |
| 4 | | D2252-17 | FRAME | 19.78 | 53 |
| | 2 | D2252-19 | FRAME | 95.27 | 45 |
| | 2 | D2252-21 | FRAME | 30.82 | 90 |
| | 1 | D2252-23 | FRAME | 30.62 | 90 |
| 2 | | D2253-1 | LUG | | |
| 2 | | D2254 | GUSSET | | |
| | 1 | D2327-1 | BUSHING | | |
| 1 | | D2327-3 | BUSHING | | |
| | 1 | D2329 | LABEL PLATE | | |
| 4 | 2 | D2581 | MOUNTING CHANNEL | | |
| A/R | A/R | | 3/4-16F EXPANDED METAL | | |

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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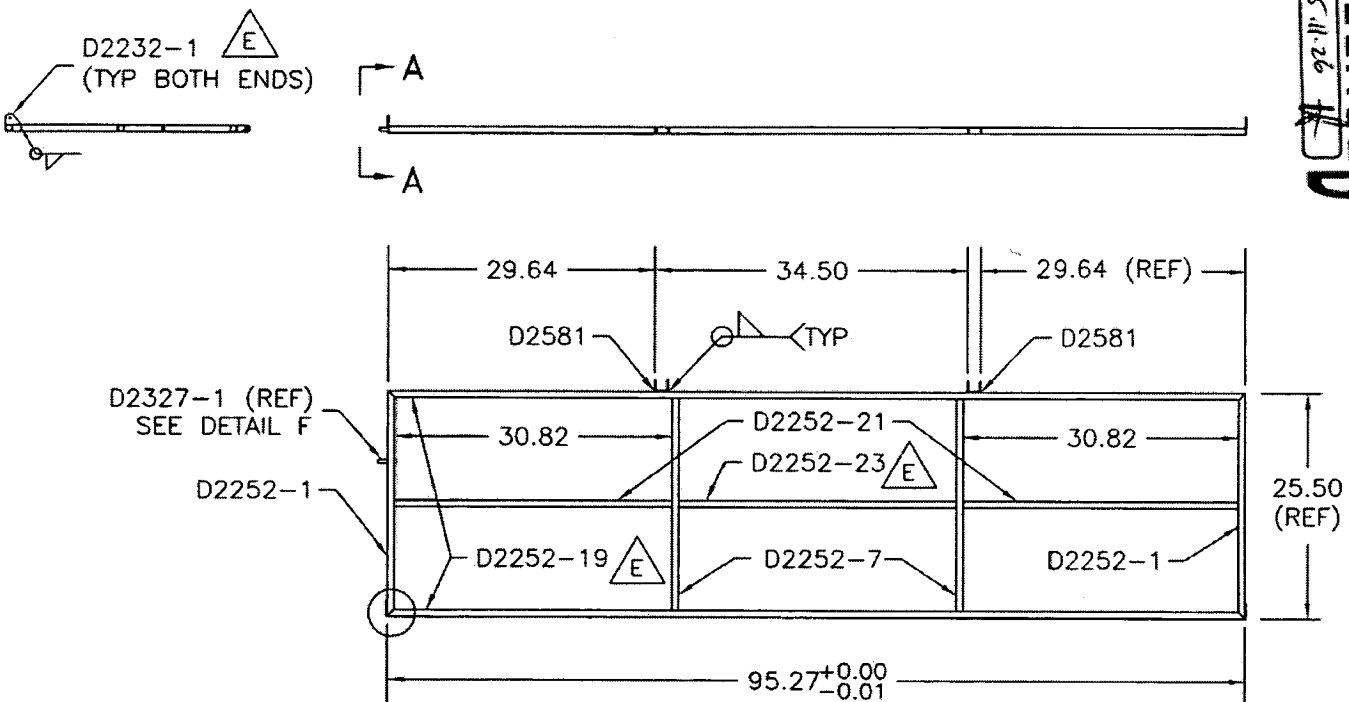
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| DATE | 05.11.10 | DRAWING NO. | D2252 | REV. E |
| | | TITLE | BASKET ASSEMBLY (206L) | SHEET 2 OF 3 |
| | | SCALE | NTS | |

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D2252-043 LID FRAME

WELD ALL JOINTS
AS SHOWN

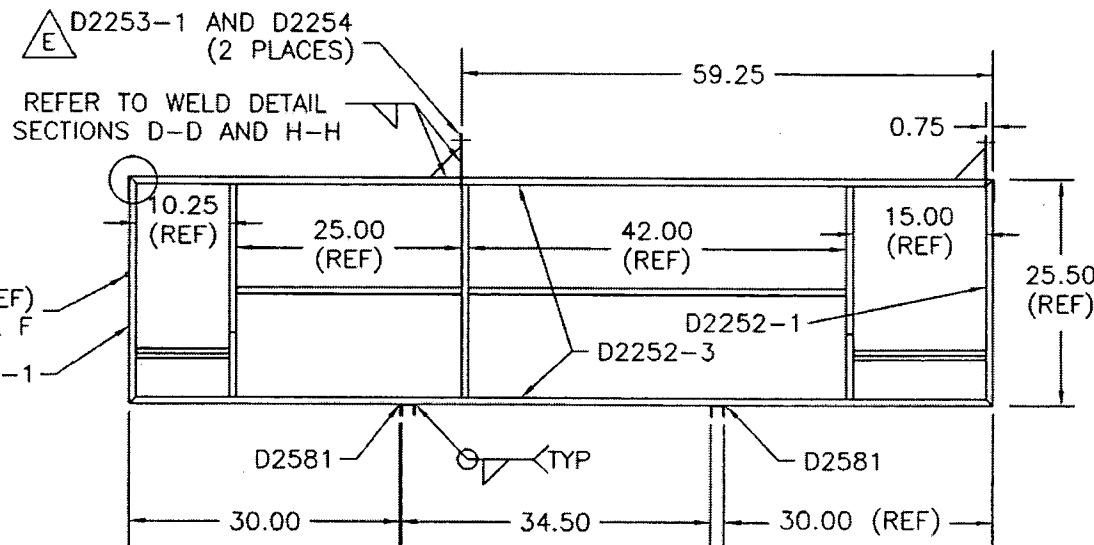
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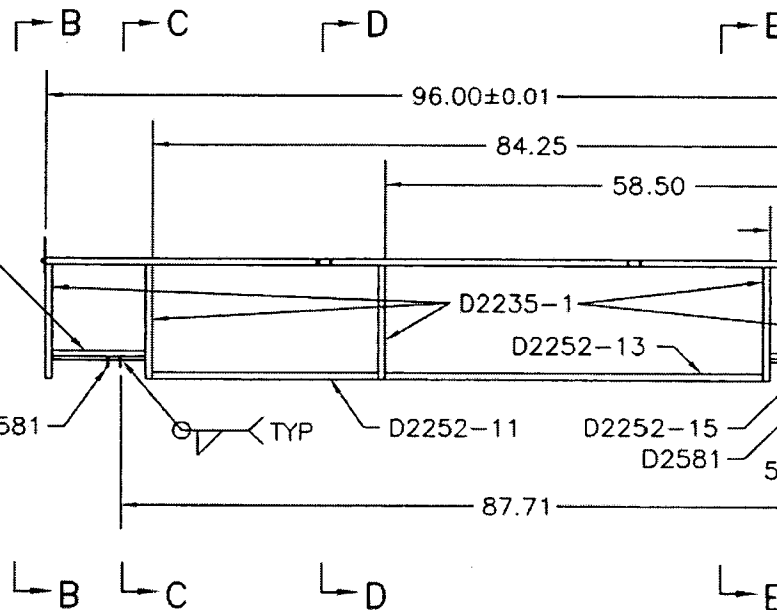
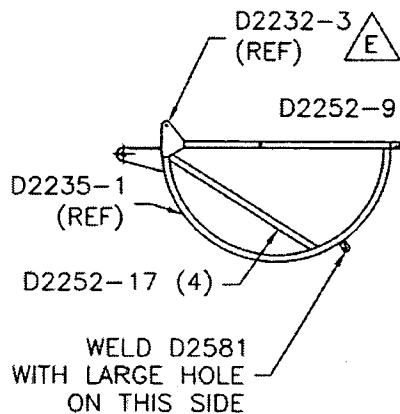
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| | | TITLE | BASKET ASSEMBLY (206L) | SHEET 3 OF 5 |
| | | | | SCALE |
| | | | | NTS |



WELD ALL JOINTS
AS SHOWN



D2252-041 BASKET FRAME

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05.11.26

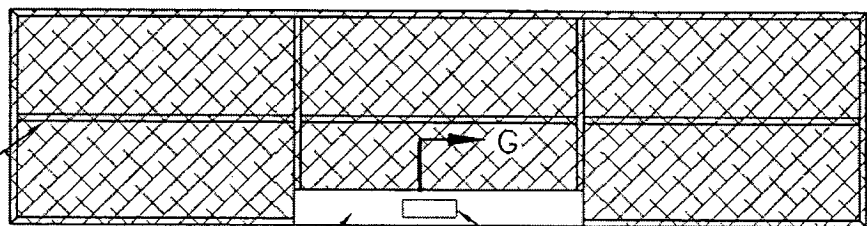
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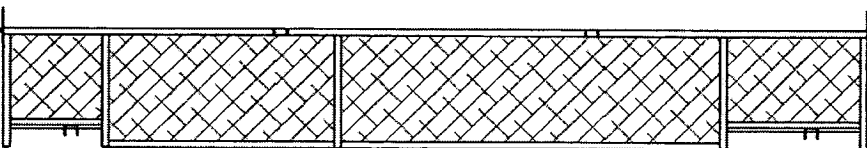
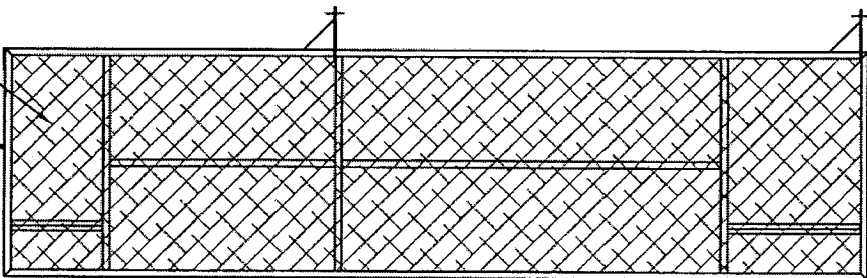
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| | | | | SHEET 4 OF 5 |
| | | | | SCALE |
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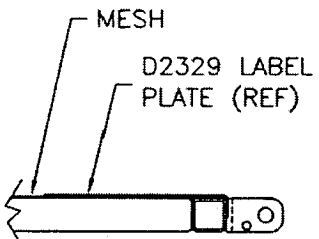
D2329 LABEL PLATE
CENTER ON THE
BASKET LID

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

D2252-043 LID ASSEMBLY



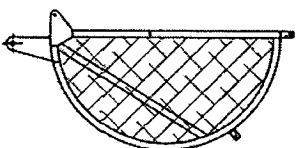
D2252-041 BASKET ASSEMBLY



SECTION G-G



SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME

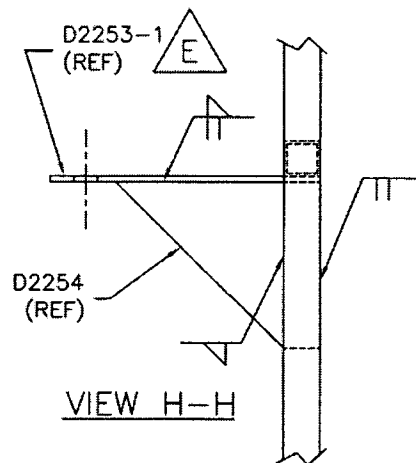
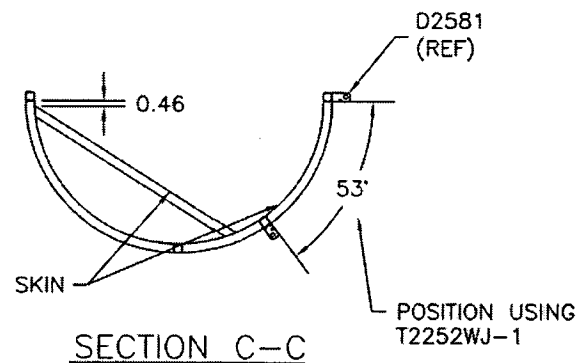
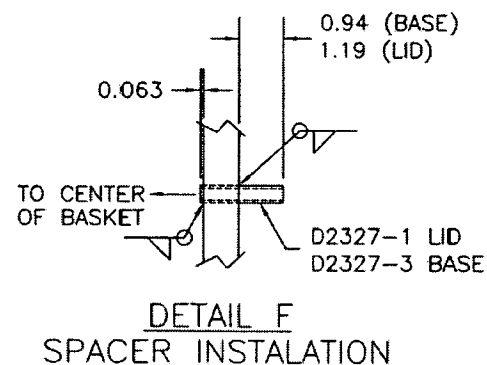
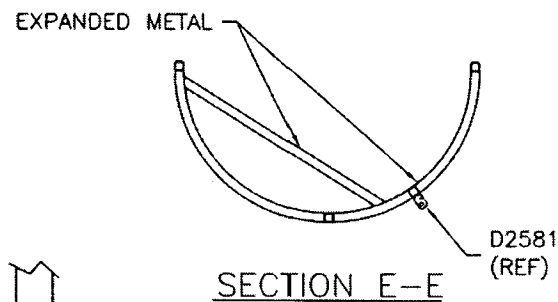


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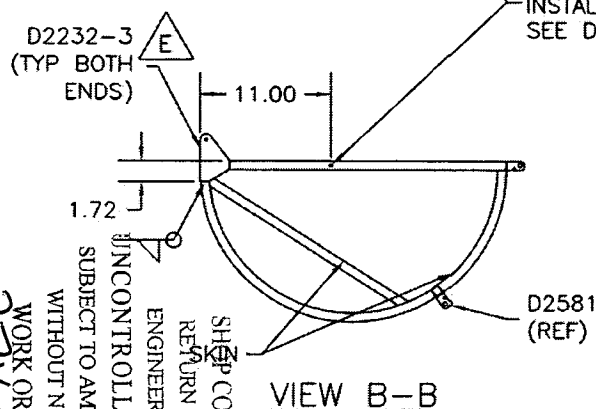
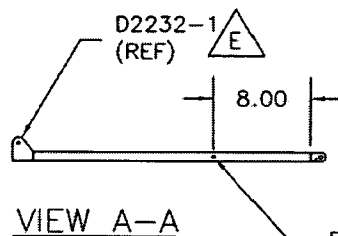
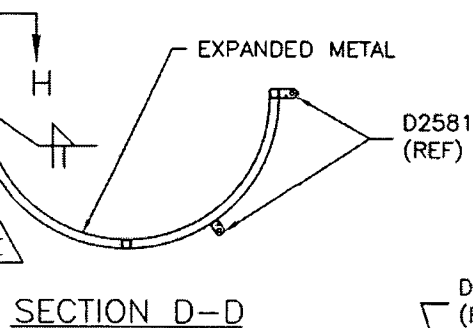
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| DATE | 05.11.10 | DRAWING NO. | D2252 | REV. E |
| | | TITLE | BASKET ASSEMBLY (206L) | SHEET 5 OF 5 |
| | | | | SCALE |
| | | | | NTS |



DRILL 3/8 HOLE AND
INSTALL D2327-1/-3
SEE DETAIL F



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05.11.20

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